

Work Order ID 120221

120221

Page 1

June-09-14 2:29:23 PM

Item ID: D3564-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Stainless Steel Wearplate Aft

Start Date: 6/04/14 Start Qty: 24.00

24

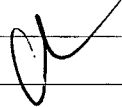
Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

105 0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24577
CUT PER DRWG D3564 REV.D

CZ 14/06/12 24

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

P-14/7/3 (24)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

DAS
27
9-89

14/7/8

30


→

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
14/07/01	125	add 4 for bend analysis - Newdges David D	DD	14-07-01	4	14-07-01	27 9-99 14/7/01

Part No: D3564-11 PAR #: D3564-11 Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3564-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Stainless Steel Wearplate Aft
 Start Date: 6/04/14 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE			DAS		20			17/07/10
Brake NC	Memo	0.00		30					
Brake NC	Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179			9-89					
140		0.00							
140	QC5- Inspect part completeness to step on W/O			DAS		20			
QC	Memo	0.00		21					
Quality Control				5-01					
150		0.00							
150	Large Fab					20			15-01-19 MAL
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 2059B Hardcoat								
	Weld hardcoat as per Dwg D3437								

M130712

Work Order ID 120221

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120221

Page 3

Item ID: D3564-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Stainless Steel Wearplate Aft
 Start Date: 6/04/14 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 50 9-89
160						20	15-1-19		
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 50 9-89
170						20	15-1-19		
QC	Memo	0.00							
Quality Control									
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							DAS 34 9-89
180						20	15-1-19		
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 11.35 OVEN TEMPERATURE:								
	FINISH TIME: 12.05								

Work Order ID 120221

June-09-14 2:29:23 PM

120221

Page 4

Item ID: D3564-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Stainless Steel Wearplate Aft
 Start Date: 6/04/14 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							DAS 38 9-89

190

QC

Memo

0.00

Quality Control

JAN 20 2015

200 Identify as per dwg & Stock Location: FR002 0.00

200

Packaging

Memo

0.00

Packaging

x20 of 16/01/20

210 QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.00

Quality Control

MLT 15-01-21

MF

15-1-20

Picklist Print

June-09-14 2:29:23 PM

Page 1

Work Order ID: 120221

120221

Parent Item: D3564-11

D3564-11

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	144.8670	1.41	36			

M304S16GA

304/316 Sheet .063

**

CX 14/06/19

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

M128423

1.2

M129192

68.1

m129545

DART AEROSPACE LTD		Work Order: 120221
Description: Wearshoe		Part Number: D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

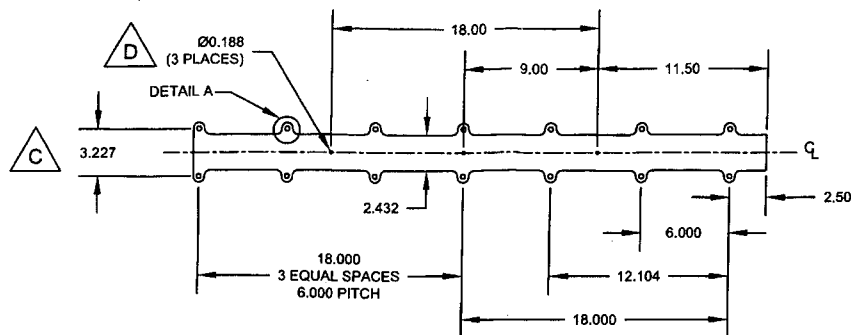
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.227"	-		✓	Jkm01
2.432	+/-0.010	2.432"	-		✓	
2.50	+/-0.030	2.50"	-		✓	
6.000	+/-0.010	6.000"	-		✓	
12.104	+/-0.010	12.104"	-		T	Jkm07
18.000	+/-0.010	18.000"	-		T	
18.00	+/-0.030	18.00"	-		T	
9.00	+/-0.030	9.005"	-		✓	Jkm08
11.50	+/-0.030	11.503"	-		✓	
0.300 x 0.300	+/-0.010	0.302 x 0.296"	-		✓	
Ø0.188	+0.005/-0.001	0.190"	-		✓	
R0.375	+/-0.010	0.375"	-		LG	
0.063	+/-0.010	0.060"	-		✓	

Measured by: DAS 23	Audited by: DAS 27	Prototype Approval:	N/A
Date: 14-09-17	Date: 14/7/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

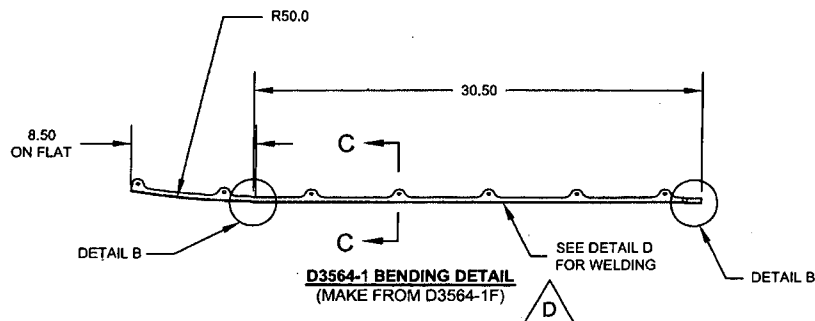


D3564-1F FLAT PATTERN

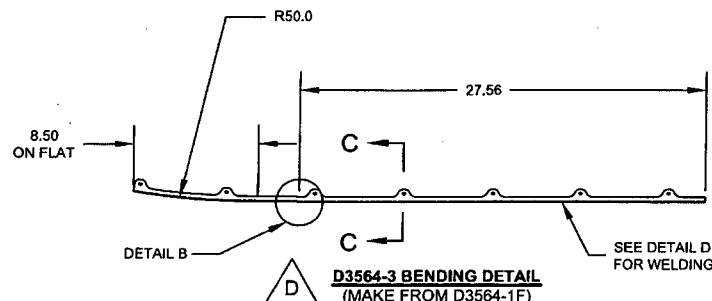
RELEASED

07.09.04

UNDER REVIEW
 11/04
 Finish change
 OK 11/11/28



D3564-1 BENDING DETAIL
 (MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
 (MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

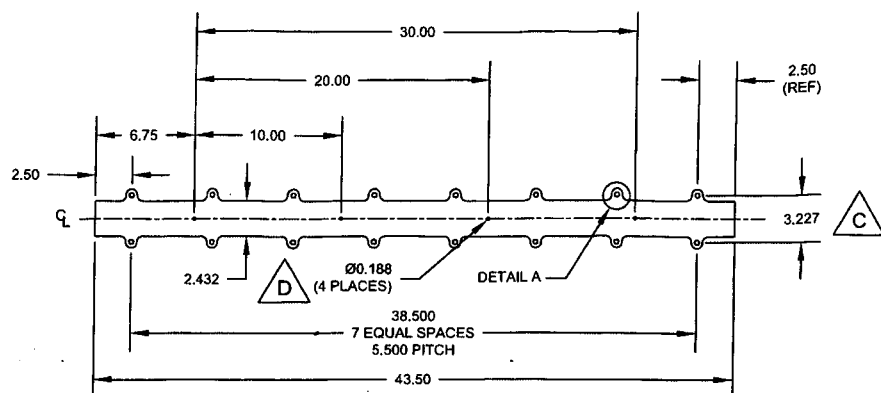
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

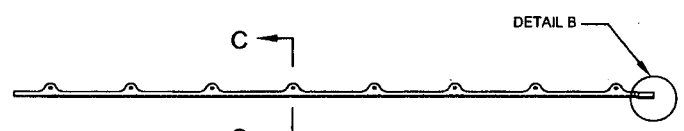
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	PH		
CHECKED	CB		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
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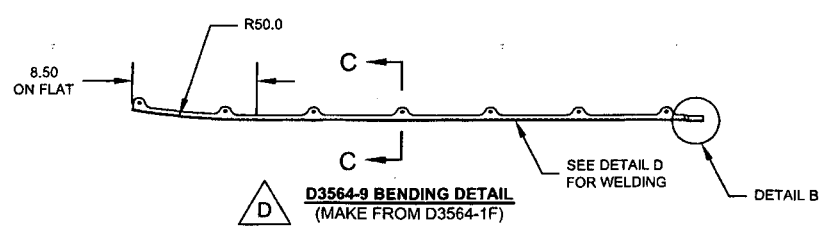
8 7 6 5 4 3 2 1



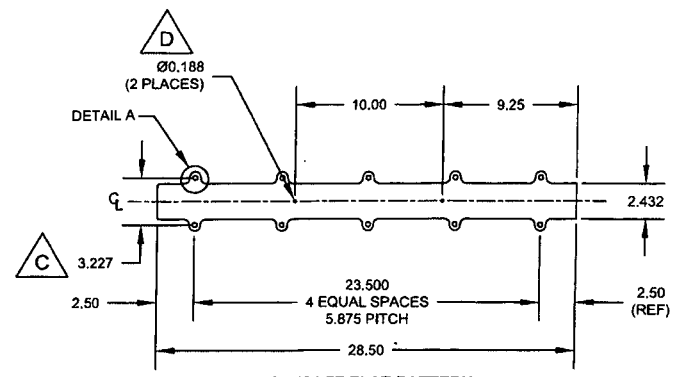
D3564-5F FLAT PATTERN



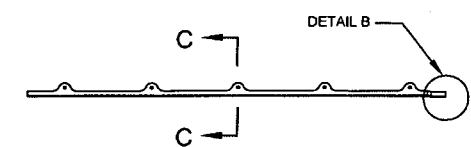
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



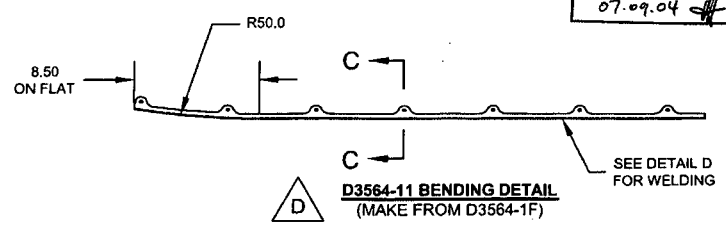
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

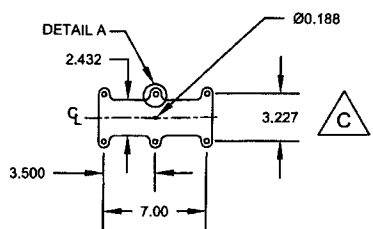
UNDER REVIEW
OK 07.11.28

RELEASED
07.09.04

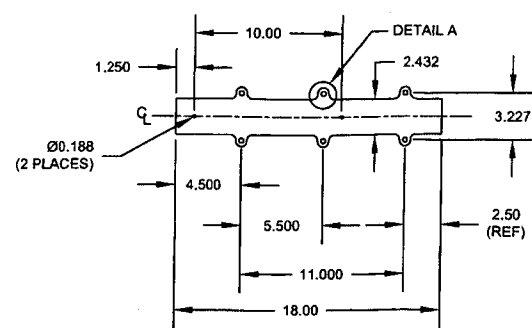
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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8 7 6 5 4 3 2 1

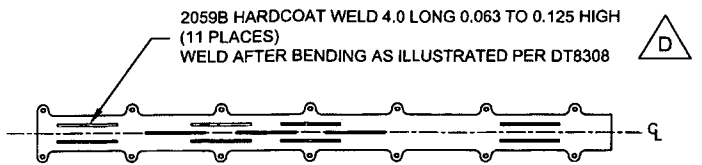
8 7 6 5 4 3 2 1



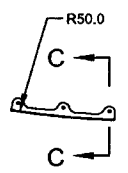
D3564-13F FLAT PATTERN



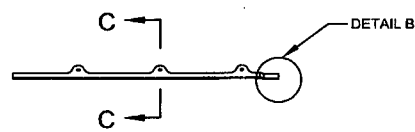
D3564-15F FLAT PATTERN



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

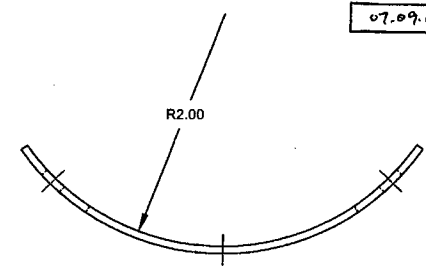


D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



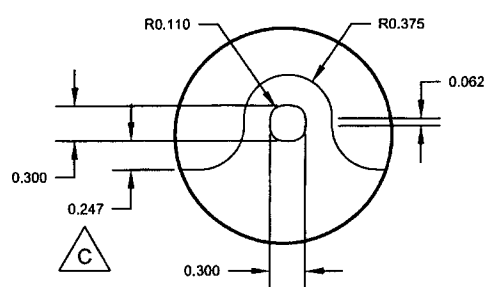
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

RELEASED
07.09.04

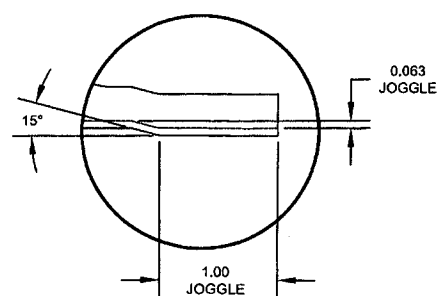


SECTION C-C
SCALE 1:1

UNDER REVIEW
OK 07.11.28



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH		SHEET 3 OF 3
APPROVED	PH	TITLE WEARSHOE	SCALE 1:8
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DATE	07.08.21		

8 7 6 5 4 3 2 1

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6177
Date: 2014-07-02
Page: 1

Sold to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Ship to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24577	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-02
Tracking No.:	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	24
d3537-1	Chaque	d3537-1 wearpad	48
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	60
d2154	Chaque	d2154 bracket stud	20
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	40
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	12
d4952-1	Chaque	d4952-1 wearplate	16
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	20
d4095-047	Chaque	d4095-047 wearplate assy	16
d4798-041	Chaque	d4798-041 wearplate assy	20
d4135-1	Chaque	d4135-1 wearpad	16
d4360-041	Chaque	d4360-041 wearplate assy	10
d2012-111	Chaque	d2012-111 bracket	8
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	40
d3171-1	Chaque	d3171-1 angle bracket	60
d3463-3	Chaque	d3463-3 step	20
d3512-1	Chaque	d3512-1 wearplate	12
d3629-1	Chaque	d3629-1 bracket	16
d3955-5	Chaque	d3955-5 plate	20
d4021-5	Chaque	d4021-5 blanking plate	12
d3556-1	Chaque	d3556-1 clamp	40

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days